



Europäisches Patentamt

(19)

European Patent Office

Office européen des brevets

(11) Publication number:

0 404 188

A1

(12)

## EUROPEAN PATENT APPLICATION

(21) Application number: 90111899.2

(51) Int. Cl. 5: C25D 3/44

(22) Date of filing: 22.06.90

(30) Priority: 23.06.89 JP 162392/89  
23.06.89 JP 162393/89

(43) Date of publication of application:  
27.12.90 Bulletin 90/52

(84) Designated Contracting States:  
DE FR GB NL

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(54) Non-aqueous electrolytic aluminum plating bath composition.

(57) There is disclosed a non-aqueous electrolytic aluminum plating bath composition comprising an aluminum halide and a nitrogen-containing heterocyclic onium halide compound and containing an additive selected from the group consisting of an inorganic halide compound, aromatic aldehyde, ketone or carboxylic acid, an unsaturated heterocyclic compound containing more than one nitrogen atom, an unsaturated heterocyclic

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compound containing a sulfur atom, an aromatic hydrocarbon compound containing a sulfur atom, an aromatic hydrocarbon compound containing an amino group and an aromatic amine; and further optionally an organic polymer. The bath composition is easy in maintenance, has good covering power, and enables smooth plating with low current density.

**Non-aqueous electrolytic aluminum plating bath composition****Field of the Invention**

This invention relates to electrolytic aluminium plating bath compositions comprising an aluminum halide, a nitrogen-containing heterocyclic onium halide compound and an inorganic or organic additive.

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**Background of the Invention**

Electrolytic plating of aluminum cannot be conducted in an aqueous system because the affinity of aluminum to oxygen is strong, and the electrolytic potential thereof is baser than hydrogen. Therefore, electrolytic plating of aluminum is conducted in a non-aqueous medium, especially in an organic medium.

Typical among the known organic electrolytic baths for aluminum plating are a bath comprising  $\text{AlCl}_3$  and  $\text{LiAlH}_4$  or  $\text{LiH}$  dissolved in ether and a bath comprising  $\text{AlCl}_3$  and  $\text{LiAlH}$  dissolved in tetrahydrofuran (THF). However, these baths contain highly reactive  $\text{LiAlH}_4$  and  $\text{LiH}$ , which react with oxygen or moisture, which may be contained in the bath, and may decompose thus deteriorating the electric current efficiency and shortening the bath life.

In order to overcome these disadvantages of the prior art, bath compositions comprising an aluminum halide and an onium salt of a nitrogen-containing heterocyclic compound have been proposed. These include bath compositions obtained by melting and mixing an aluminum halide and an N-alkylpyridinium halide (Japanese Laid-Open Patent Publication No. Sho 62-70592 and Sho 62-70593), a bath composition obtained by melting and mixing an aluminum halide and a 1-alkyl- or 1,3-dialkylimidazolium halide (Japanese Laid-Open Patent Publication No. Hei 1-272790), etc.

These bath compositions are liquid at room temperature and free from the danger of ignition, and if an aluminum anode is used, the bath is continuously replenished with aluminum as the aluminum in the bath is consumed. These bath compositions are more advantageous than other bath compositions in that the maintenance of the bath is easy and thus the operation is simpler.

Recently, electrolytically aluminum-plated products having a thick aluminum coating of no less than 10 - 50 pm, inter alia, anodized products, are attracting attention as corrosion-resistant materials.

When thick aluminum plating is conducted using any of the above-described bath compositions comprising an aluminum halide and an onium salt of nitrogen-containing heterocyclic compound, however, aluminum is not uniformly deposited but particles thereof grow locally larger, making the surface irregular, and that the particles on the surface may come off under friction. The irregularity of the surface spoils the (surface) luster and, therefore, such products are not suitable to be used as reflectors or the like.

One measure for overcoming the above problems is to add an organic solvent such as benzene, toluene, or the like to the bath in an amount of 1 - 2 moles per mole aluminum halide. However, addition of such a large amount of organic solvent is not preferable because the solvent deteriorates the working environment by evaporation thereof and, moreover, invites danger of ignition.

Further, the above-described bath compositions are inferior in covering powder and, therefore, when shaped bodies are plated, concaved parts where the current density is not more than  $0.01 \text{ A/dm}^2$  may not be plated.

The present invention provides an electrolytic aluminum plating bath composition which enables overall, uniform, dense and smooth plating with low current density.

We have found that the above-described problems can be overcome by addition of specific organic heterocyclic compounds, and organic polymers, if desired, to the above-described bath compositions.

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**Summary of the Invention**

This invention provides a non-aqueous electrolytic aluminum plating bath composition which comprises (1) 40 - 80 mol% of an aluminum halide, (2) 20 - 60 mol% of a nitrogen-containing heterocyclic onium halide (a halide of an onium of a nitrogen-containing heterocyclic compound), (3) at least one additive selected from the group consisting of 0.0005 - 0.05 mol/l of a halide represented by the formula  $\text{MX}_n$ , wherein M is Ag, C, Sn(II), Pb, Sb, S or Se, X is a halogen and n is an integer corresponding to the valency of the M element; 0.0005 - 0.1 mol/l of an aromatic aldehyde, aromatic ketone, aromatic carboxylic acid or derivative thereof; an unsaturated heterocyclic compound containing more than one nitrogen atom; an unsaturated

heterocyclic compound containing a sulfur atom; an aromatic hydrocarbon compound containing a sulfur atom; an aromatic hydrocarbon compound containing an amino group; an aromatic amine and optionally (4) 30 mg/t - 1 g/t of an organic polymer.

5 Aluminum halide is represented by the formula AlX<sub>3</sub>, wherein X is a halogen atom. Specific examples are AlF<sub>3</sub>, AlCl<sub>3</sub>, AlBr<sub>3</sub> and AlI<sub>3</sub>.

The aluminum halide is used in an amount of 40 - 80 mol% in the plating bath, preferably 50 - 70 mol% and more preferably 55 - 67 mol%. In a system where the amount of the aluminum halide is too small, the reaction, which may be considered to be the decomposition of the onium cation, occurs, while in a system where the amount thereof is too large, the viscosity of the bath tends to be increased undesirably.

10 The nitrogen-containing heterocyclic onium halide used for the bath composition of the present invention is a heterocyclic compound, the nitrogen atom (as the hetero atom) of which forms a cationized ammonium radical. Generally, it comprises a five-membered or six-membered ring. The hetero ring may have substituents or may be comprised of a fused ring. Preferred substituents are alkyl and alkylamino, which preferably contain 1 to 12 carbon atoms.

15 Specific examples are pyridinium halide such as pyridinium chloride; monoalkylpyridinium halide such as butylpyridinium chloride, etc.; di- and trialkylpyridinium halide such as 1,2-dimethylpyridinium chloride, 1-ethyl-2-methylpyridinium chloride, 1-ethyl-2-methylpyridinium bromide, 1-ethyl-2-methylpyridinium iodide, 1-ethyl-2-methylpyridinium fluoride, 1-n-butyl-2-methylpyridinium chloride, 1-isobutyl-2-methylpyridinium chloride, 1-isobutyl-2-methylpyridinium chloride, 1-isobutyl-2-methylpyridinium chloride, 1-n-octyl-2-methylpyridinium chloride, 1-benzyl-2-methylpyridinium chloride, 1-ethyl-3-methylpyridinium chloride, 1-ethyl-3-methylpyridinium bromide, 1-cyclohexyl-3-methylpyridinium bromide, 1-ethyl-2-ethylpyridinium chloride, 1-butyl-2-ethylpyridinium chloride, 1-ethyl-4-methylpyridinium bromide, 1-ethyl-4-phenylpyridinium bromide, 1-ethyl-2,4-dimethylpyridinium chloride, 1-n-butyl-2,4-dimethylpyridinium chloride, etc.; 1-alkyl-aminopyridinium halide such as 1-methyl-4-dimethylaminopyridinium iodide, 1-ethyl-4-dimethylaminopyridinium chloride, 1-ethyl-4-(N-ethyl-N-methyl)-aminopyridinium chloride, 1-ethyl-4-aminopyridinium iodide, 1-n-butyl-4-dimethylaminopyridinium fluoride, 1-benzyl-4-dimethylaminopyridinium chloride, 1-n-octyl-4-dimethylaminopyridinium chloride, 1-ethyl-4-piperidinopyridinium bromide, 1-ethyl-4-pyrrolidinopyridinium chloride, 1-ethyl-4-pyrrolidinopyridinium bromide, etc.; imidazolium halides such as imidazolium chloride, etc.; alkylimidazolium halide such as ethylimidazolium chloride, etc.; 1-alkyl, 1,3-dialkyl, 1,2,3-trialkylimidazolium halide such as 1-methylimidazolium bromide, 1-ethyimidazolium chloride, 1-butylimidazolium chloride, 1,3-dimethylimidazolium bromide, 1-methyl-3-ethyimidazolium iodide, 1-methyl-3-n-butylimidazolium chloride, 1-methyl-3-benzylimidazolium chloride, 1-methyl-3-ethyylimidazolium chloride, 1,2,3-trimethylimidazolium bromide, 1,2,3-trimethylimidazolium iodide, 1,2-dimethyl-3-ethyylimidazolium bromide, 1,2-dimethyl-3-butylimidazolium fluoride, etc.; dialkylbenzimidazole halide such as 1,3-dimethylbenzimidazolium chloride, 1-methyl-3-ethylbenzimidazolium chloride, 1-methyl-3-ethylbenzimidazolium bromide, 1-methyl-3-ethylbenzimidazolium iodide, etc.

Among these, alkylpyridinium halide and dialkyl imidazolium halide are preferred because they provide the plating bath with high electric conductivity.

40 The nitrogen-containing heterocyclic compound onium halide is contained in the plating bath preferably in an amount of 30 - 50 mol%, more preferably 33 - 45 mol% in the bath.

Of the halides used in the present invention, halides of Ag, Sn(II), Pb and Sb make the surface of the plated layer smoother although metallic luster is not improved while those of C, S and Se improve metallic luster and surface smoothness. It is preferred to use a metal halide, the halogen atom of which is the same as the halogen atom of the used aluminum halide.

45 The halide is contained in the plating bath preferably in an amount of 0.0008 - 0.01 mol/t, more preferably 0.00095 - 0.0015 mol/t. When the halide content is too small, the surface-smoothing effect is poor while with more than 0.1 mol/t, deposition of eutectoid increases deteriorating corrosion resistance of the plated layer.

50 Specific examples of the aromatic aldehyde, ketone, carboxylic acid and derivatives thereof are aldehydes such as benzaldehyde, salicylaldehyde, anisaldehydes, etc.; ketones such as acetophenone, benzophenone, etc.; carboxylic acids and derivatives thereof such as phthalic acid, methyl benzoate, etc.

Specific examples of the unsaturated heterocyclic compound containing more than one nitrogen atoms are pyrimidine, naphthyline, phenazine, phenanthroline, pyridazine, pyrazine, etc.

55 Specific examples of the unsaturated heterocyclic compound containing a sulfur atom are thiophene, etc.

Specific examples of the aromatic hydrocarbon compound containing a sulfur atom are thiophenol, thiobenzoic acid etc.

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Specific examples of the aromatic hydrocarbon compound containing an amino group are diphenylamine, aminopyrimidine, etc.

These organic compounds have the effect of improving covering power when plating is effected with low current density and are contained in the plating bath preferably in an amount of 0.001 - 0.05 mol/l, and 5 more preferably, 0.001 - 0.01 mol/l. When these organic compound is contained in an amount of more than 0.1 mol/l, burning may be caused when plating is conducted with high current density.

Any organic polymer can be used insofar as it is soluble in the molten salt bath and stable under the plating conditions. The molten salt bath has high dissolving ability and dissolves almost all polymers other than high corrosion-resistant polymers such as fluorine resin. Preferred polymers are ethylene polymers 10 having aromatic substituents or polyethers. Specific examples of ethylene polymers having aromatic substituents are polystyrene, polyvinylcarbazol, etc. These polymers preferably have a molecular weight of 2700 - 400,000.

The polymer is added to the plating bath in an amount of 30 mg/l - 1 g/l, preferably 30 mg/l - 500 mg/l and more preferably 50 mg/l - 100 mg/l. When a sufficient amount of the polymer is not contained, 15 covering power is not well improved at the low current density portions and with more than 1 g/l, burning is caused when plating is conducted with high current density.

The plating bath of the present invention comprising an aluminium halide, a nitrogen-containing heterocyclic onium halide and an additional component can be obtained by melting and mixing the above components under an inert atmosphere or suspending the above components in a suitable solvent and 20 mixing them under warming and thereafter removing the solvent.

When plating is carried out with the plating bath of the present invention, plating is effected in a dry oxygen-free atmosphere in the same way as when conventional plating baths are used. Electrolysis is suitably conducted with direct or pulse current with a current density of 0.01 - 50 A/dm<sup>2</sup> at 0 - 150 °C with good current efficiency effecting uniform plating. At a temperature lower than 0 °C, uniform plating is not 25 obtained. At a temperature higher than 150 °C, reduction of nitrogen-containing heterocyclic onium is caused giving a grey plating layer and coarse dendritic crystals and thus spoiling the appearance and workability when plating is carried out with a current density of higher than 50 A/dm<sup>2</sup>.

### 30 Specific Disclosure of the Invention

Now the invention will be specifically illustrated by way of working examples.

### 35 Examples 1 - 32

A cold-rolled mild steel sheet having a thickness of 0.5 mm was subjected to ordinary solvent vapor washing, alkali defatting and pickling. After being dried, the sheet was immersed in a molten salt bath of the present invention, the composition of which is indicated in Table 1, and aluminum plating was effected 40 using the steel sheet as the cathode and an aluminum plate (99.99% pure, 1 mm thick) as the anode under the electrolysis conditions as indicated in Table 1. The results are also shown in Table 1.

### 45 Comparative Example 1

Aluminum plating of cold-rolled mild steel sheet was carried out with a plating bath consisting of AlCl<sub>3</sub> and butylpyridinium chloride. The bath composition, plating conditions and the results are shown in Table 1.

### 50 Comparative Example 2

Aluminum plating of cold-rolled mild steel sheet was carried out with a plating bath consisting of AlCl<sub>3</sub> and 1-ethyl-3-methylimidazolium chloride. The bath composition and the results are shown in Table 1.

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### Examples 33 - 44

Molten baths comprising an aluminum halide, a nitrogen-containing heterocyclic onium halide com-

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pound, an unsaturated heterocyclic compound and an organic polymer, the compositions of which are shown in Table 2-1, were prepared. Using these plating baths, 0.5 mm thick cold-rolled mild steel sheets were electrolytically plated with aluminum. The plating was effected by washing the cold-rolled mild steel sheets with solvent vapor in accordance with the usual procedure, defatting them with alkali, pickling and drying them, immersing them in a plating bath and carrying out electrolysis using a cold-rolled steel sheet as the cathode and an aluminum plate (99.99% pure, 1 mm thick) as the anode with direct current under the conditions indicated in Table 2-2. The properties of the plated products are also shown in Table 2-2.

**10 Comparative Examples 3 and 4**

Electrolytic aluminum plating was carried out using the baths under the conditions as indicated in Table 2-1, i.e. without any additive and polymer. The results are also shown in Table 2-2.

As has been described above, the plating bath composition which comprises an aluminum halide, a nitrogen-containing heterocyclic onium halide compound, and a specified additive and optionally organic polymer has better covering power, gives plated layers having smoother surface.

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Table 1-1

	Run No.	Bath Composition		Conditions of Electrolysis			Current efficiency (%)	Plated layer		
		AlX <sub>3</sub>	Nitrogen-containing heterocyclic onium halide	Additive	Temp (°C)	Current density (A/dm <sup>2</sup> )		Time (min)	Atmosphere	
Working Examples	1	AlCl <sub>3</sub> 60 mol%	Butylpyridinium chloride 40 mol%	AgCl 0.001 mol/l	40	10	15	N <sub>2</sub> gas	98	30
	2	AlBr <sub>3</sub> 55 mol%	Methylpyridinium bromide 45 mol%	SnBr <sub>2</sub> 0.001 mol/l	60	20	10	Ar gas	98	40
	3	AlF <sub>3</sub> 60 mol%	Ethylpyridinium fluoride 40 mol%	S <sub>2</sub> Cl <sub>2</sub> 0.001 mol/l	80	30	10	Ar gas	97	60
	4	AlCl <sub>3</sub> 67 mol%	Butylpyridinium chloride 33 mol%	CCl <sub>4</sub> 0.001 mol/l	60	20	10	N <sub>2</sub> gas	98	40
	5	AlCl <sub>3</sub> 67 mol%	Ditto 33 mol%	PbCl <sub>2</sub> 0.001 mol/l	60	20	10	N <sub>2</sub> gas	98	40
	6	AlCl <sub>3</sub> 67 mol%	Ditto 33 mol%	SbCl <sub>4</sub> 0.001 mol/l	60	20	10	N <sub>2</sub> gas	99	40
	7	AlCl <sub>3</sub> 67 mol%	Ditto 33 mol%	SeCl 0.001 mol/l	60	20	10	N <sub>2</sub> gas	99	40
	8	AlCl <sub>3</sub> 60 mol%	Ditto 40 mol%	Thiophene 0.01 mol/l	60	20	10	N <sub>2</sub> gas	100	40
	9	AlCl <sub>3</sub> 65 mol%	Ditto 35 mol%	Thiophenol 0.01 mol/l	60	20	10	N <sub>2</sub> gas	98	40

Table 1-2

	Run No.	Bath Composition		Conditions of Electrolysis			Current efficiency (%)	Thickness (μm)	$X' t$	Workability	Plated layer
		$\text{AlX}_3$	Nitrogen-containing heterocyclic onium halide	Additive	Temp. (°C)	Current density ( $\text{A}/\text{dm}^2$ )					
Working Examples	10	$\text{AlCl}_3$ 65 mol%	Butylpyridinium chloride 35 mol%	Aniline 0.005 mol/l	60	0.05	120	$\text{N}_2$ gas	98	1.2	Dense, Non-lustrous
	11	$\text{AlCl}_3$ 65 mol%	Ditto 35 mol%	Pyrimidine 0.001 mol/l	60	30	10	$\text{N}_2$ gas	99	60	Dense, Lustrous
	12	$\text{AlCl}_3$ 65 mol%	Ditto 35 mol%	Aminopyrimidine 0.005 mol/l	60	30	10	$\text{N}_2$ gas	99	60	Dense, Lustrous
	13	$\text{AlCl}_3$ 65 mol%	Ditto 35 mol%	Benzaldehyde 0.01 mol/l	60	30	10	$\text{N}_2$ gas	99	60	Dense, Non-lustrous
	14	$\text{AlCl}_3$ 65 mol%	Ditto 35 mol%	Benzophenone 0.01 mol/l	60	30	10	$\text{N}_2$ gas	99	60	Dense, Non-lustrous
	15	$\text{AlCl}_3$ 65 mol%	Ditto 35 mol%	Phthalic acid 0.005 mol/l	60	30	10	$\text{N}_2$ gas	98	60	Dense, Lustrous
Comparative Example	1	$\text{AlCl}_3$ 65 mol%	Ditto 35 mol%	-	60	10	15	$\text{N}_2$ gas	98	-	Surface remarkably rough

Table 1-3

	Run No.	Bath Composition			Conditions of Electrolysis			Current efficiency (%)	Thickness ( $\mu\text{m}$ )	$X \cdot t$	Plated layer
		AlX <sub>3</sub>	Nitrogen-containing heterocyclic cation halide	Additive	Temp. (°C)	Current density (A/dm <sup>2</sup> )	Time (min)				
Working Examples	17	AlCl <sub>3</sub> 60 mol%	1-Ethylimidazolium chloride 40 mol%	AgCl 0.001 mol/l	60	10	15	N <sub>2</sub> gas	98	30	Dense, Non-lustrous
	18	AlBr <sub>3</sub> 35 mol%	1-Octylimidazolium bromide 35 mol%	SnBr <sub>2</sub> 0.001 mol/l	40	30	10	Ar gas	99	60	Dense, Lustrous
	19	AlF <sub>3</sub> 60 mol%	1-Ethyl-3-methylimidazolium fluoride 40 mol%	S <sub>2</sub> Cl <sub>2</sub> 0.001 mol/l	60	10	30	N <sub>2</sub> gas	100	60	Dense, Lustrous
	20	AlCl <sub>3</sub> 67 mol%	Butylpyridinium chloride 33 mol%	CCl <sub>4</sub> 0.001 mol/l	60	20	10	N <sub>2</sub> gas	98	40	Dense, Lustrous
	21	AlCl <sub>3</sub> 67 mol%	Ditto 33 mol%	PbCl <sub>2</sub> 0.001 mol/l	60	20	10	N <sub>2</sub> gas	98	40	Dense, Non-lustrous
	22	AlCl <sub>3</sub> 67 mol%	Ditto 33 mol%	SbCl <sub>4</sub> 0.001 mol/l	60	20	10	N <sub>2</sub> gas	99	40	Dense, Lustrous
	23	AlCl <sub>3</sub> 67 mol%	Ditto 33 mol%	SeCl 0.001 mol/l	60	20	10	N <sub>2</sub> gas	99	40	Dense, Non-lustrous
	24	AlCl <sub>3</sub> 65 mol%	1,3-Diethylimidazolium chloride 35 mol%	Thiophene 0.01 mol/l	40	15	10	N <sub>2</sub> gas	99	30	Dense, Non-lustrous
	25	AlCl <sub>3</sub> 60 mol%	1-Butyl-3-propylimidazolium chloride 40 mol%	Thiophenol 0.01 mol/l	80	30	5	Ar gas	98	30	Dense, Non-lustrous

Table 1-4

	Run No.	Bath Composition		Conditions of Electrolysis				Current efficiency (%)	Plated layer		
		AlX <sub>3</sub>	Nitrogen-containing heterocyclic anion halide	Additive	Temp. (°C)	Current density (A/dm <sup>2</sup> )	Time (min)		Thickness (μm)	X' t	Workability
Working Examples	26	AlCl <sub>3</sub> 55 mol%	1,3-Diethylimidazolium chloride 45 mol%	Aniline 0.005 mol/l	60	0.05	120	Ar gas	99	1.2	Dense, Non-lustrous
	27	AlCl <sub>3</sub> 65 mol%	1-Ethyl-3-methylimidazolium chloride 35 mol%	Pyrimidine 0.001 mol/l	60	50	3	N <sub>2</sub> gas	99	30	Dense, Lustrous
	28	AlCl <sub>3</sub> 65 mol%	Ditto 35 mol%	Aminopyrimidine 0.005 mol/l	60	50	3	N <sub>2</sub> gas	98	30	Dense, Lustrous
	29	AlCl <sub>3</sub> 65 mol%	Ditto 35 mol%	Benzaldehyde 0.01 mol/l	60	50	3	N <sub>2</sub> gas	99	30	Dense, Non-lustrous
	30	AlCl <sub>3</sub> 65 mol%	Ditto 35 mol%	Benzophenone 0.01 mol/l	60	50	3	N <sub>2</sub> gas	99	30	Dense, Non-lustrous
	31	AlCl <sub>3</sub> 65 mol%	Butylpyridinium chloride 35 mol%	Phthalic acid 0.005 mol/l	60	50	3	N <sub>2</sub> gas	98	30	Dense, Lustrous
	32	AlCl <sub>3</sub> 67 mol%	Ditto 33 mol%	Aminopyrimidine 0.003 mol/l	60	50	3	N <sub>2</sub> gas	99	30	Dense, Lustrous
	Comparative Example	2 AlCl <sub>3</sub> 65 mol%	1-Ethyl-3-methylimidazolium chloride 35 mol%	.	60	50	3	N <sub>2</sub> gas	-	-	Burning caused

Table 2-1

Run No.	Bath Composition				
		Aluminum halide	Nitrogen-containing heterocyclic onium halide compound	Additive	Organic Polymer
Working Examples	33	AlCl <sub>3</sub> 60 mol%	Butylpyridinium chloride 40 mol%	Pyrimidine 0.001 mol/l	Polystyrene 100 mg/l
	34	AlCl <sub>3</sub> 65 mol%	Ditto 35 mol%	Naphthylidine 0.003 mol/l	Ditto 50 mg/l
	35	AlCl <sub>3</sub> 65 mol%	Ditto 35 mol%	Phenazine 0.005 mol/l	EO-PO copolymer 100 mg/l
	36	AlCl <sub>3</sub> 65 mol%	Ditto 35 mol%	Phenanthroline 0.003 mol/l	Ditto 500 mg/l
	37	AlCl <sub>3</sub> 65 mol%	Ditto 40 mol%	Diphenylamine 0.01 mol/l	Polystyrene 100 mg/l
	38	AlCl <sub>3</sub> 65 mol%	Ditto 35 mol%	Aminopyrimidine 0.01 mol/l	EO-PO copolymer 100 mg/l
	39	AlCl <sub>3</sub> 60 mol%	1-Ethylimidazolium chloride 40 mol%	Pyrimidine 0.001 mol/l	Polystyrene 100 mg/l
	40	AlCl <sub>3</sub> 65 mol%	1-Ethyl-3-methylimidazolium chloride 35 mol%	Naphthylidine 0.003 mol/l	Ditto 50 mg/l
	41	AlCl <sub>3</sub> 65 mol%	Ditto 35 mol%	Phenazine 0.005 mol/l	EO-PO copolymer 100 mg/l
	42	AlCl <sub>3</sub> 65 mol%	Ditto 35 mol%	Phenanthroline 0.003 mol/l	Ditto 500 mg/l
	43	AlCl <sub>3</sub> 65 mol%	Ditto 35 mol%	Diphenylamine 0.01 mol/l	Polystyrene 100 mg/l
	44	AlCl <sub>3</sub> 65 mol%	Ditto 35 mol%	Aminopyrimidine 0.01 mol/l	EO-PO copolymer 100 mg/l
Comparative Examples	3	AlCl <sub>3</sub> 65 mol%	Butylpyridinium chloride 35 mol%	-	-
	4	AlCl <sub>3</sub> 65 mol%	1-Ethyl-3-methylimidazolium chloride 35 mol%	-	-
EO = ethylene oxide PO = propylene oxide					

Table 2-2

Run No.	Conditions of Electrolysis			Current efficiency (%)	Thickness (μm)	Plated layer		Workability
	Temp. (°C)	Current density (A/dm <sup>2</sup> )	Time (min)			X'4		
Working Examples	33	60	0.05	120	N <sub>2</sub> gas	98	1.2	Dense, Non-lustrous Smooth, good covering power
	34	60	30	10	N <sub>2</sub> gas	99	60	Dense, Lustrous Good covering power
	35	60	30	10	N <sub>2</sub> gas	99	60	Dense, Lustrous Good covering power
	36	60	0.05	120	N <sub>2</sub> gas	98	1.2	Dense, Non-lustrous Smooth, good covering power
	37	60	30	10	N <sub>2</sub> gas	99	60	Dense, Non-lustrous Smooth, good covering power
	38	60	0.05	120	N <sub>2</sub> gas	98	1.2	Dense, Non-lustrous Smooth, good covering power
	39	60	0.05	120	Ar gas	99	1.2	Dense, Non-lustrous Smooth, good covering power
	40	60	50	3	N <sub>2</sub> gas	99	30	Dense, Lustrous Good covering power
	41	60	50	3	N <sub>2</sub> gas	99	30	Dense, Lustrous Good covering power
	42	60	0.05	120	N <sub>2</sub> gas	98	1.2	Dense, Non-lustrous Smooth, good covering power
Comparative Example	43	60	50	3	N <sub>2</sub> gas	99	30	Dense, Non-lustrous Smooth, good covering power
	44	60	0.05	120	N <sub>2</sub> gas	98	1.2	Dense, Non-lustrous Smooth, good covering power
	3	60	30	10	N <sub>2</sub> gas	98	60	Rough surface, Poor covering power
	4	60	10	10	N <sub>2</sub> gas	98	60	Rough surface, Poor covering power

**Claims**

- 5           1. A non-aqueous electrolytic aluminum plating bath composition which comprises:
- (1) 40 - 80 mol% of an aluminum halide,
  - (2) 20 - 60 mol% of a nitrogen-containing heterocyclic onium halide,
  - (3) an additive selected from:
- 10         0.0005 - 0.05 mol/l of a halide compound represented by the formula  $MX_n$ , wherein M is Ag, C, Sn(II), Pb, Sb, S or Se, X is a halogen atom and n is an integer corresponding to the valency of the M element; and 0.0005 - 0.1 mol/l of an organic compound selected from a group consisting of an aromatic aldehyde, aromatic ketone, aromatic carboxylic acid or derivatives thereof; an unsaturated heterocyclic compound containing more than one nitrogen atom; an unsaturated heterocyclic compound containing a sulfur atom;
- 15         an aromatic hydrocarbon compound containing a sulfur atom; an aromatic hydrocarbon compound containing an amino group and an aromatic amine, and optionally
- (4) 30 mg/l - 1 g/l of an organic polymer.
- 20         2. The composition as claimed in Claim 1, wherein the aluminum halide is one of bromide, chloride and fluoride.
- 20         3. The composition as claimed in Claim 1, wherein the nitrogen-containing heterocyclic onium halide is an N-alkylpyridinium halide or a (di)alkylimidazolium halide.
- 25         4. The composition as claimed in Claim 1, wherein the nitrogen-containing heterocyclic onium halide is a compound selected from the group consisting of butylpyridinium chloride, methylpyridinium bromide, ethylpyridinium fluoride, 1-ethylimidazolium chloride, 1-octylimidazolium bromide, 1-ethyl-3-methylimidazolium fluoride, 1-butyl-3-propylimidazolium chloride, 1,3-diethylimidazolium chloride and 1-ethyl-3-methylimidazolium chloride.
- 30         5. The composition as claimed in Claim 1, wherein the additive is selected from the group consisting of AgCl, SnBr<sub>2</sub>, CCl<sub>4</sub>, PbCl<sub>2</sub>, SbCl<sub>4</sub>, SeCl, thiophene, thiophenol, aniline, pyridine, aminopyridine, benzaldehyde, benzophenone, phthalic acid, pyrimidine, naphthylidine, phenazine, diphenylamine and phenanthroline.
- 35         6. The composition as claimed in Claim 1, wherein the organic polymer is contained.
- 35         7. The composition as claimed in Claim 6, wherein the organic polymer is selected from the group consisting of polystyrene and ethylene oxide-propylene oxide copolymer.
- 35         8. The composition as claimed in Claim 1, wherein the content of the aluminum halide is 50 - 70 mol% and the content of the nitrogen-containing heterocyclic onium halide content is 30 - 50 mol%.
- 40         9. The composition as claimed in Claim 1, wherein the content of the compound  $MX_n$  is 0.001 - 0.05 mol/l, the content of the aromatic aldehyde, aromatic ketone, aromatic carboxylic acid; the unsaturated heterocyclic compound; the unsaturated heterocyclic compound containing a sulfur atom; the aromatic hydrocarbon compound containing a sulfur atom; or the aromatic hydrocarbon compound containing an amino group is 0.001 - 0.05 mol/l.
- 40         10. The composition as claimed in Claim 6, wherein the organic polymer content is 0.03 - 0.5 g/l.

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## EUROPEAN SEARCH REPORT

Application Number

EP 90 11 1899

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 5)
A	CHEMICAL ABSTRACTS, vol. 80, 1974, page 429, abstract no. 152099d, Columbus, Ohio, US; & JP-A-74 01 440 (NISSHIN STEEL CO.) 08-01-1974 ---		C 25 D 3/44
A	CHEMICAL ABSTRACTS, vol. 94, 1981, page 546, abstract no. 38700g, Columbus, Ohio, US; & SU-A-775 185 (G.D. ROZENSHTEIN et al.) 30-10-1980 -----		
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			C 25 D
<p>The present search report has been drawn up for all claims</p>			
Place of search	Date of completion of the search	Examiner	
THE HAGUE	25-09-1990	NGUYEN THE NGHIEP	
CATEGORY OF CITED DOCUMENTS		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	
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